

GRIDUR 250B



IDENTIFICATION : GRIDUR 250 B

SPECIFICATION : DIN 8555 E 1-UM -250

CHARACTERISTICS :

Hydrogen controlled basic type electrode for tough easily machinable welds.

TYPICAL APPLICATION :

Gridur 250B electrode is used for medium hardness hard facing with high resistance to abrasion both by sliding and rolling action. The tough weld metal can also withstand hard blows. Among other applications, Gridur 250B recommended for the last 2-3 layers of the rail welding process. The slag is easily removable and the weld metal can be machined with cutting tools.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Cr
0.12 - 0.18	0.9 - 1.35	0.9 - 1.30	0.025 max	0.025 max	8.0 - 9.0

HARDNESS IN AS-WELDED CONDITION : 250-280 BHN

REDRYING OF ELECTRODES : 300°C / 2 Hrs

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS
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3.15	450	100-140
4.00	450	150-200
5.00	450	200-260